PART 6

INSPECTION, TESTING AND COMMISSIONING REQUIREMENTS

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PART 6

INSPECTION, TESTING AND COMMISSIONING REQUIREMENTS

6.1 Inspection and Testing During Manufacture

General

(a) All inspection and testing shall be carried out in accordance with the Specification and in absence of Specification relevant Indian Standard or internationally approved equivalent standard. After award of contract, Contractor shall furnish a QA plan for approval by Employer. QA plan shall include testing for incoming supply of raw materials and bought out items, stage inspections and tests on finished products at manufacturer's works / appropriate testing station. QA plan shall clearly indicate tests which are intended to be witnessed by the Contractor alone and those by both contractor and Employer.

(b) Inspection and tests schedule shall be as follows;

1) Manufacture tests
2) Acceptance inspection / Quantity checking
3) Install /site inspection
4) Site acceptance test
5) Tests on Completion
6) Process Wet Tests (by Raw Sewage)
7) Operation Test (Tests After Completion)

(c) The Contractor shall carry out at the place of manufacture tests of the Plant /Equipment at any part of the Works.

(d) The Employer and/or duly authorised and designated representative(s) shall be entitled to attend the aforesaid inspection and/or tests.

(e) The Employer and his duly authorised representative shall have access to the Contractor's premises at all times to inspect and examine the material and workmanship of the mechanical and electrical plant and equipment during its manufacture there. If part of the plant and equipment is being manufactured on other premises, the Contractor shall obtain permission for the Employer or his duly authorised representative, to inspect as if the plant and equipment was manufactured on the

Contractors own premises. Testing (including testing for chemical analysis and physical properties) shall be carried out by the Contractor and certificates submitted to the Engineer who will have the right to witness or inspect the above mentioned inspection /testing at any stage desired by him. Where inspection or testing is to be carried out at a subcontractor's works, a representative of the Contractor shall be present.

(f) Contractor shall provide test procedure, pre-factory test results, and calculation sheet, photo in advance and provide all of test result with necessary document including its data and photo to show Engineer that test is carried out in proper condition and the its test results.

(g) The procedure for the testing and inspection to be carried out during or following the manufacture of the materials to ensure the quality and workmanship of the materials and to further ensure that they conform to the Contract in whatever place they are specified shall be as described below.

(i) The Contractor shall give the Employer at least 21 clear days notice in writing of the date and the place at which any plant or equipment will be ready for inspection/testing as provided in the Contract. The Employer or his duly authorised representative shall thereupon at his discretion notify the Contractor of his intention either to release such part of the plant and equipment upon receipt of works tests certificates or of his intention to inspect. The employer shall then give notice in writing to the Contractor, and attend at the place so named the said plant and equipment which will be ready for inspection and/or testing. As and when any plant shall have passed the tests referred to in this section, the Engineer shall issue to the Contractor a notification to that effect.

(ii) The Contractor shall forward to the Employer 6 duly certified copies of the test certificates and characteristics performance curves for all equipment.

(iii) If the Engineer(s) fails to attend the inspection and/or test, or if it is agreed between the parties that the Engineer(s) shall not do so, then the Contractor may proceed with the inspection and/or test in

the absence of the Engineer and provide the Employer with a certified report of the results thereof as per (ii) above.

(iv) If any materials or any part of the works fails to pass any inspection / test, the Contractor shall either rectify or replace such materials or part of the works and shall repeat the inspection and/or test upon giving a notice as per (i) above. Any fault or shortcoming found during any inspection or test shall be rectified to the satisfaction of the Engineer before proceeding with further inspection of that item. Any circuit previously tested, which may have been affected by the rectification work, shall be re-tested.

(v) Where the plant and equipment is a composite unit of several individual pieces manufactured in different places, it shall be assembled and tested as one complete working unit, at the maker's works.

(vi) Neither the execution of an inspection test of materials or any part of the works, nor the attendance by the Engineer(s), nor the issue of any test certificate pursuant to (iii) above shall relieve the Contractor from his responsibilities under the Contract.

(vii) The test equipment, meters, instruments etc., used for testing shall be calibrated at recognised test laboratories at regular intervals and valid certificates shall be made available to the Engineers at the time of testing. The calibrating instrument used as standards shall be traceable to National/International standards. Calibration certificates or test instruments shall be produced from a recognised/Laboratory for the Engineer's consent in advance of testing and if necessary instruments shall be recalibrated or substituted before the commencement of the test.

(viii) Items of plant or control systems not covered by standards shall be tested in accordance with the details and program agreed between the Engineer and Contractor's Representative. If such materials or works are found to be defective or not conforming to the Contract requirements, due to the fault of the Contractor or his sub-contractors the Contractor shall defray all the expenses of such inspection and/or test and of satisfactory reconstruction.

(ix) Tests shall also be carried out such that due consideration is given to the Site conditions under which the equipment is required to function. The test certificates shall give all details of such tests.

(x) The Contractor shall establish and submit a detailed procedure for the inspection of materials or any part of the works to the Employer for approval within the date indicated in the Programme Details. The detailed procedure shall indicate or specify, without limitation, the following :

- Applicable code, standard, and regulations.
- Fabrication sequence flow chart indicating tests and inspection points.
- Detailed tests and inspection method, indicating the measuring apparatus to be used, items to be measured, calculation formula, etc.
- Acceptance criteria.
- Test report forms and required code certificates and data records.
- Method of sampling, if any sampling test to be conducted.
- Contractor's or Employer's witness points.

(xi) The Contractor shall not pack for shipment any part of the Plant until he has obtained from the Employer or his authorised representative his written approval to the release of such part for shipment after any tests required by the Contract have been completed to the Employer's satisfaction.

(xii) The following Inspection and Testing procedures shall be carried out for the equipment as applicable.

The detailed procedure shall indicate or specify, without limitation, the following:

- Visual Inspection.
- Dimension Checking
- Dynamic balancing for all rotating parts
- Hydrostatic / Leak testing for all pressure parts, Pneumatic Leak Test wherever applicable
- Operation check
- Liquid penetrant tests or magnetic particle tests for all machined surfaces of pressure parts.

(h) The Contractor shall maintain proper identification of all materials used, along with reports for all internal / stage inspection work carried out, based on the specific job requirement and or based on the datasheets / drawings / specifications.

(i) The expenses incurred during inspection shall include, but not be limited to all travelling, boarding, lodging and out-of- pocket expenses.

(1) For inspections within India, the Contractor shall incur all the expenses of Employer and Engineer. All the Contractor's expenses with respect to the aforementioned inspection(s) shall be reimbursed by the Employer against the provisional sum inclusive of contingencies on production of documentary evidence and invoice.

(2) For inspection outside India, the Contractor shall incur the expenses of Employer, Engineer and delegates of Engineer. All the Contractor's expenses with respect to the aforementioned inspection(s) shall be reimbursed by the Employer against the provisional sum inclusive of contingencies on production of documentary evidence and invoice.

(3) However, cost of inspection when material or any part of the facilities is not ready at the time specified by the Contractor for inspection or when reinspection is necessitated by prior rejection shall be borne by the Contractor and will not be reimbursed.

(j) Witnessed testing will normally be waived on standard types of equipment such as small motors made by approved manufacturers, individual standardised instruments, small mass produced components used in the manufacture of Plant items, small bore pipework and fittings, minor installation materials and low voltage cable. In order to remove doubt this shall not relieve the Contractor of his obligation under the Contract to ensure that all Plant is tested at the manufacturer's works prior to delivery to Site.

(k) As a guide to the Contractor the Employer reserves the right to witness testing of the following but not limited to the following Plant items:

a) Electrical:

(1) 415 V Metal enclosed switchgears (PCC)/ MCC

(2) Variable Frequency Drives
(3) Power & control cables

b) Mechanical:

(1) Storage and process vessels
(2) Scraper bridge
(3) Mixers, pumps and blowers including their motors rated at greater than 25 kW
(4) Valve and pen stock actuators
(5) Valves and non return valves greater than 300 mm diameter
(6) Pipes more than 200 mm diameter
(7) Sluice Gates
(8) Weir Gates
(9) Mechanical Coarse and Fine Screens
(10) Dewatering Machine and associated plant
(11) Fine Bubble Diffuser systems
(12) Process Air Blowers

c) Instrumentation and Control:

(1) Flow Measuring System
(2) DO analyzer
(3) ORP analyzer
(4) Instrumentation and Control Cables

(l) All destructively tested samples shall be replaced with new.

(m) The Employer reserves the right to be present during the testing and inspection of all Plant items.

Materials, Plant and Equipment

The Contractor shall place orders for the material and the equipment only after approval of the Engineer. The Contractor shall submit the detailed drawings from the approved manufacturer and the procedure of submission, review and revision shall be as specified herein below.

The Contractor shall inform the Employer about the likely dates of manufacturing, testing, and dispatching of any material and equipment to be incorporated into the Permanent Works. The Contractor shall notify the Employer for inspection and testing, at least twenty-eight (28) days prior to

packing and shipping and shall supply the manufacturer's test results and quality control certificates. The Employer will decide whether he or his representative (Engineer) will inspect and test the material / equipment or whether he will approve it on the basis of the manufacture’s certificate.

The following inspection and test categories shall be applied prior to delivery of the equipment, of various categories as indicated in the technical specifications for each type of the equipment:

Category A: -The drawings have to be approved by the Engineer before manufacture and testing. The material has to be inspected by the Engineer or a third party inspecting agency approved by the Employer at the manufacturer’s premise before packing and dispatching. The inspection charges of the agency will be borne by the Employer. The Contractor shall provide the necessary equipment and facilities for tests and the cost thereof shall be borne by the Contractor.

Category B: - The drawings of the equipment have to be submitted and approved by the Engineer prior to manufacture. The material has to be tested by the manufacturer and the manufacturer’s test certificates are to be submitted and approved by the Engineer before dispatching of the equipment. Not withstanding the above, the Employer, after examination of the test certificates, reserves the right to instruct the Contractor for retesting, if required, in the presence of the Contractor’s representative.

Category C: - Samples of the materials and/or equipment shall be submitted to the Engineer for pre-construction review and approval in accordance with the provisions of Sub-Clause 5.5, Section 2. Following approval by the Employer, the material may be manufactured as per the approved standards and delivered to the Site.

For material/equipment under Category “A” and “B”, the Employer will provide an authorization for packing and shipping after inspection.

The testing and approval for dispatching shall not absolve the Contractor from his obligations for satisfactory performance of the plant.

6.2 Factory Acceptance Test (FAT) Document

Fifty six (56) days prior to commencement of inspection of each Plant item / equipment the Contractor shall supply a Factory Acceptance Test (FAT) Document for approval. This shall comprise four copies of the following:

- Unpriced copy of the Contractors order for the Plant item / equipment concerned:
- Details of the inspection and test procedures to be carried out.
- Pre-factory test results and its photos.

The FAT Plan shall provide comprehensive details of the tests to be carried out, the purpose of each test, the equipment to be used in carrying out the test and the methods to be adopted in carrying out the tests. The FAT shall provide space within the documentation for results of the tests to be added and for each test and for the FAT as a whole to be signed off by the Contractor and the Engineer.

On completion of the tests the Contractor shall provide four copies of all test certificates, curves etc. for the inspected Plant item. To remove doubt test certificates shall be provided for the Plant item as a whole plus certificates for the relevant component parts such as:

- Motors;
- Mixers, pumps and Blowers;
- Instruments;
- Gear boxes;
- Electrical switchgear rated in excess of 250 A;
- Integral control and switchgear panels;
- Valve gear;
- Castings.
- Actuators
- Screens
- Fine bubble diffusers
- Pumps /blowers
- Air blowers

6.3 Inspection and Testing Programme

The Contractor shall submit to the Engineer not later than 56 days prior to the commencement of the first inspection and test during manufacture a programme detailing the inspection dates for all Plant. Those items of Plant that

the Engineer has specifically identified for witness testing test shall be highlighted in the programme.

The Contractor shall keep the Engineer informed of any changes to the programme.

The Engineer shall not be requested to inspect an item of Plant until the Contractor has satisfied himself that the equipment meets all requirements of the Employer’s Requirements.

The Contractor shall inform the Engineer in writing at least 21 days in advance regarding readiness for carrying out inspection of equipment/material etc. at manufacturer's works or at places of inspection. The programme for inspection shall be finalised by the Engineer after the receipt of the above. In case inspection cannot be carried out due to non-readiness of equipment/material etc. a subsequent date shall be finalised for carrying out the inspection in which event all expenses incurred by the Corporation for such visits shall be recovered from the Contractor. In case equipment/material etc. is found not to comply with the specification, dates for re-inspection shall be finalised and expenses incurred by the Corporation for such visits shall also be recovered from the Contractor. Contractor's Representatives shall essentially be present during all inspections. The following information shall be given in the inspection call letter mentioned above:

(a) Name of manufacturer/supplier;

(b) Address of place where inspection is to be carried out;

(c) Proposed date/s and equipment to be inspected;

(d) Name/s of contact personnel at manufacturer's/ supplier/s works with their telephone and fax numbers.

(e) Name of Contractor's Representative who will be present during the inspection.

(f) Confirmation that internal testing has been completed.

The Contractor shall provide all the necessary instruments, test facility, water / electric power, test piece, samples, engineers/ workers, all cost and others to

carry out the tests after assembly. All instruments used for such tests shall be calibrated and certified by and approved by an independent testing authority not more than one month prior to the tests in which they are used. Calibration certificates with expire date and name of authorization agency for instruments used for such tests shall be produced for the approval of the Engineer and if necessary, instruments shall be recalibrated before the commencement of the tests.

No material shall be delivered to the Site without inspection having been carried out or waived in writing by the Engineer.

If during or after testing, any item of plant fails to achieve its intended duty or otherwise proves defective, it shall be modified or altered as necessary and retested and re-inspected as required by the Engineer.

6.4 Tests at Manufacturer's Premises – Mechanical Equipment

6.4.1 Sewage / Sludge Pumps

(a) All pumps shall be assembled completely in the shop to ensure correct fitting of all parts and shall be match-marked before shipment.

(b) All pumps shall undergo witness performance tests at the pump manufacturer’s Works. Testing shall be undertaken with the respective motors for all the pumps being supplied under the Contract.

(c) All tests such as Q/H curve, efficiency of pumps, power consumption, vibration and noise level shall be conducted, and NPSH tests one for each pumping station shall be undertaken to verify that the pumps meet the specified criteria. The pumps shall be run at constant flow capacity and speed.

(d) Pump casings shall be subject to hydrostatic pressure testing as an assembly at 150% of the pump shut-off head or 200% of the pump rated head whichever is higher. The hydrostatic pressure shall be held for not less than 30 minutes after all leaks have been stopped between attachments.

(e) Impeller and pump rotating assembly shall be dynamically balanced as per ISO 1940 / Gr. 6.3 / VDI 2060.

(f) Standard running test shall be conducted as per BS 5316 Part 2 Class B / ISO 3555 at the rated speed at manufacturer's works to measure the capacity, total head, efficiency and power. These tests shall form the basis for pump acceptance except for vibration and noise. The pump shall be tested over a range comprising shut off head to maximum flow. Minimum five readings approximately equidistant shall be taken for plotting the performance curve.

(g) The following formula shall be taken for computing the power input to the pump:

Power input to the Pump in kW: $\frac{Q \times Hx1.02}{367.2 \times \eta_p}$

Where, Q = Discharge in cum/hr
H = Total head in mwc
η_p = Efficiency of pump

(h) If the vibration, noise level readings taken during performance test show higher than that permitted, vendor shall guarantee to show that the values shall be maintained at site after erection. Any cost of rectification needed on this count shall be borne by the Contractor.

6.4.2 Motors

(a) Routine Tests
All routine tests shall be carried out on all motors as per the latest edition of IS 325.

(b) Acceptance Tests
Full load test to determine efficiency, power factor and slip shall be conducted on all the motors.

(b) Type tests

The following type tests shall be carried out on one motor of each rating above 18.5 kW.

23 Isolation resistance test
24 Temperature rise test

25 Momentary overload test

(1) Vibration measurement test
(2) Noise level test
(3) Over speed /over load test
(4) Starting current, starting torque, and pull out torque at reduced voltage

6.4.3 Valve

(a) During testing there shall be no visible evidence of structural damage to any of the valve component.

(b) Motorized valves shall be tested with their actuators, with a differential head equivalent to their maximum working pressure, to prove that the actuators are capable of opening and closing the valves under maximum unbalanced head condition within the specified opening or closing period.

(c) Hydrostatically tested shall be as per relevant IS/BS standard for each type of valve.

(d) The following test shall be carried out for sluice valves, Knife Gate valves:

(1) Pressure test
(2) Leakage test
(3) Seat leakage test.
(4) Body hydrostatic test.
(5) Valve operation

(e) The following test shall be carried out for non-return valves:

(1) Pressure test
(2) Leakage test
(3) Seat leakage test.
(4) Body hydrostatic test.
(5) Valve operation

6.4.4 Pipe-work

Testing of pipes and fitting shall be carried out in accordance with relevant Indian Standard and internationally approved standard. Pipes, fittings and

expansion bellows shall be hydrostatically tested for 1.5 times the rated pressure.

The following test shall be carried out for pipelines:

(1) Pressure test
(2) Leakage test
(3) Colour check for welding pipeline
(4) Welding beat check

6.4.5 Blowers

Tests shall be carried out in accordance with the relevant international standard. All compressors and blowers shall be tested with their ancillaries to confirm design performance particularly in respect of flow and pressure. The test shall demonstrate that vibration and noise are within the specified limits and that the pressure relief valve operates correctly.

Air receiver shall be tested in accordance with the relevant section of B.S. 5169.

All pressure vessels shall be inspected and hydro water tightness tested.

6.4.6 Process Plant Items

All process plant items shall be tested to ensure they meet the Employer's Requirements for quality of workmanship, construction, and performance.

6.4.7 Sluice Gates

(a) Seat Clearance Check

With the gate fully closed, the clearance between seating faces when checked with the thickness gauge, shall not exceed 0.1 mm.

(b) Movement Tests

Each gate shall be shop operated three times from the fully open position to the fully closed position and return to fully open, under no flow conditions to demonstrate that the assembly is workable.

(c) Leakage Tests

With the gate in closed position design pressure shall be applied for a period not lesser than 5 minutes to the unseating side of the sluice gate and the leakage shall not exceed the maximum leakage permissible as per IS 13349.

(d) Hydrostatic Tests.

Finally a differential of one and a half times the design pressure shall be applied to the unseating side of the gate. Under these tests no part shall show any deflection of deformation.

6.4.8 Mechanically Raked / Fine Band Screens

(a) All screens shall be checked for overall dimensions, clearance between the bars / aperture size and its material as well as painting works.

(b) Conveyor shall be checked for dimensions and physical conditions, belt joint portion, travelling accuracy of belt, motors and its power consumption, performance of safety device.

(c) At least one screen of each type shall be tested for efficiency and operation by employing screenings. For the screen having depth of channel more than 3 metres, testing with reduced depth is acceptable.

6.4.9 Fine Bubble Diffusers

(a) Clean water Standard Oxygen Transfer Efficiency (SOTE) tests shall be performed for each different diffuser grid geometry/arrangement proposed in the design. These tests shall be performed by the diffuser Manufacturer at the Manufacturer’s testing facility or an equivalent facility appropriately equipped with an adequately sized testing tank and other required appurtenances. The testing shall be performed in full compliance with the latest version of the applicable standard testing protocol. These tests shall be witnessed by Engineer per procedures set forth for witnessing elsewhere in this document.

(b) All diffusers shall be thoroughly inspected by Contractor for physical damage to the membrane or any other part of the diffuser and results of the inspection shall be reported to Engineer.

6.5 Field Testing

A. All Fine bubble diffused aeration systems will be field tested.

B. Testing will verify the installation as well as the diffuser's ability to deliver the specified air flow rates at the manufacturer's stated pressure loss. Testing will also verify the uniformity of mixing provided.

C. Levelling tests:

1. Introduce clear water into each tank to the top of the diffuser elements.
2. Check the level of the diffusers to verify that all element horizontal surfaces are within 10 mm of a common horizontal plane and at the specified elevation.

D. Leakage and distribution of flow tests:

1. After successful completion of the levelling tests, raise the water level to 50mm above the manifold.
2. Visually inspect the water surface to ensure that the airflow is uniformly distributed across the tank.
3. Repair any leaks in the elements holders, elements, pipes or the like.
4. Repeat the test until the installation is essentially void of air leaks.

6.6 Pump-sets

All the pump-sets other than sludge pumps shall be tested for performance as per IS 5120.

6.7 Steel Cylinders Pipes and Specials

a) Welding beat check Remove all scale on the welding points and welding beat and its thickness shall be checked by the Engineer.

b) Penetration Test

A suitable liquid penetrant (kerosene oil/Dye) is applied to the surface of the portion under examination and is permitted to remain there for sufficient time to allow the liquid to penetrate into any defects open at the surface. After the penetrant time, the excess penetrant which remains on the surface is removed. Then a light coloured powder absorbent called a developer is applied to the surface. This developer acts as a blotter and draws out a portion of the penetrant which had previously seeped into the surface openings. As the penetrant is drawn out it diffuses into the coating of the developer, forming indication of the surface discontinuities or flaws.

c) Each steel cylinder shall be subjected before lining/coating to a hydrostatic test under a water pressure equivalent to the test pressure in accordance with Clause 10 of IS:1916 and relevant provisions of IS:3597, provided that the whole of the area of the calculated reinforcement is used in the steel cylinder. In the case of pipes where a part of the principal reinforcement is provided in the cage, the steel cylinder shall be subjected to proportionately less hydrostatic test pressure.

d) Manufacturer's standard specials shall be hydrostatically tested before lining/coating. Where feasible, other specials shall be hydrostatically tested (before lining/coating) at factory. However, when this is not practicable, at the discretion of the Engineer, the unlined specials shall be tested by penetration test as per IS:3658 or other approved means.

6.8 Ductile Iron Pipes

Mechanical Tests

Mechanical tests shall be carried out during manufacture of pipes and fittings as specified in relevant IS codes. The results so obtained shall be considered to represent all the pipes and fittings of different sizes manufactured during that period and the same shall be submitted to the Engineer. The method for tensile tests and the minimum tensile strength requirement for pipes and fittings shall be as per relevant IS codes.

Brinell Hardness Test

For checking the Brinell hardness, the test shall be carried out on the test ring or bars cut from the pipes used for the ring test and tensile test in accordance with IS 1500.

Retests

If any test piece representing a lot fails in the first instance, two additional tests shall be made on test pieces selected from two other pipes from the same lot. If both the test results satisfy the specified requirements, the lot shall be accepted. Should either of these additional test pieces fail to pass the test, the lot shall be liable for rejection.

Hydrostatic test

For hydrostatic test at works, the pipes and fittings shall be kept under test pressure as specified in relevant IS codes for 15 seconds, they may be struck moderately with a 700 g hammer. They shall withstand the pressure test without showing any leakage, sweating or other defect of any kind. The hydrostatic test shall be conducted before coating the pipes and fittings.

6.9 Tests at Site - Mechanical Equipment

(a) In addition to the progressive supervision and inspection by Engineer, the Contractor shall offer for inspection to Engineer, the completely erected plant/part of Plant on which tests are to be carried out. After such inspection, each equipment/sub-system shall be tested by the Contractor in accordance with the applicable standards in the presence of Engineer. Such tests shall include but not be limited to the tests specified in following clauses.

(b) The Contractor shall possess during the entire working period the Electrical Contractor's licence of appropriate class from the concerned statutory authorities governing the area of work place. The Contractor shall fully comply with the relevant statutory rules and regulations. On completion of the installation or at intermediate stages, if required by the statutory authorities, the Contractor shall arrange for inspection and obtain the approval from the concerned statutory authorities. If any fees

are to be paid to statutory authorities for testing, inspection and calibration these shall be paid by the Contractor and shall be included in his erection and commissioning charges.

6.10 Pumps, piping and valves

(a) The erected pipe work shall be subjected to a hydraulic test at 1.5 times the maximum pressure or twice the working pressure whichever is higher to test the soundness of the joints. Provision of the necessary pumps, gauges, blank flanges, tappings etc. for carrying out these tests shall be included in the Contract. All gas piping shall be air tested to twice normal working pressure.

(b) Leakage tests shall be carried out on all erected pipework, pumps and valves immediately after erection and where possible before being built in.

(c) Operating tests shall be conducted on valves.

(d) The pump set shall be tested for satisfactory operation. The vibration and noise level shall be checked to be within the specified limits.

6.11 Motors

Condition of winding insulation be tested and insulation values shall be restored to required level by suitable heating arrangements locally.

6.12 Screen

After erection, the screen shall be tested for its performance for checking its capability to handle stringy materials. Clearance between the dead plate and tines shall be checked.

6.13 Sluice Gate

(a) Leakage test shall be performed by the Contractor after installation of the Sluice Gates.

(b) Under the design seating head and unseating head the leakage shall not exceed the limit specified in IS:13349, for shop testing.

6.14 Steel Cylinder Pipes and Specials

(a) After laying and jointing of steel cylinder pipes and specials with concrete lining and coating is completed the pipeline shall be washing out with sufficient water and be tested at work site as per the following Employer's Requirements and as directed by the Engineer. All equipment for testing at work site shall be supplied and erected by Contractor. Water for testing of pipes shall be arranged by him. Damage during testing shall be Contractor's responsibility and shall be rectified by him to the full satisfaction of the Engineer. Water used for test shall be removed from pipes and not released to the excavated trenches.

(b) Each section of the pipe line shall be slowly filled with clean water and all air shall be expelled from the pipeline. The pressure in the pipeline should then be raised and maintained by means of pump to the test pressure. The test pressure should not be less than 1 1/2 times the working pressure at the lowest point or the static head pressure, whichever is higher. Under the test pressure no leak or sweating shall be visible at the welded joints. The duration of test shall be not less than 24 hours. The exposed joints shall be carefully examined and all such joints showing visible leaks shall be rewelded. Any cracked or defective pipes and specials in consequences of this pressure test shall be removed and replaced by sound material by Contractor and the test shall be repeated to the satisfaction of the Engineer.

(c) Hydrostatic shop test for pipes and fittings shall be as per code/standard requirement. After erection at site, complete pipes and fittings shall be hydrostatically tested for a pressure of 1.5 times operating pressure.

(d) Where directed by the Engineer welded joints on pipes larger than 675 mm diameter shall be subject to a nitrogen gas test after welding.

(e) A tapped hole (approximately 6 mm diameter) shall be made in the socket end of each pipe by the Contractor and shall be fitted with a suitable non-return valve. Nitrogen, at 400 kPa pressure, shall then be pumped into the annular space between the spigot and socket and the pump disconnected.

(f) If no drop in pressure occurs over the ensuing period of 30 minutes the test shall be deemed to be successful. If the test pressure cannot be maintained for 30 minutes all defects in the weld shall be cut back and rewelded and the test reapplied until successful. The cost of initial and subsequent testing of defective welds shall be at the Contractor's own expense.

(g) The Contractor shall provide all items necessary for the nitrogen tests including compressor, valves, gauges and tubing.

6.15 Ductile Iron Pipes and Fittings

(a) After the pipes and fittings are laid, jointed and the trench partially backfilled except at the joints the stretch of pipe line as directed by Engineer shall be subjected to pressure test and leakage test after washing the pipe line out with sufficient water.
Where any section of the pipeline is provided with concrete thrust blocks or anchorages, the pressure test shall not be made until at least five days have elapsed after the concrete was cast. If rapid hardening cement has been used in these blocks or anchorages, the tests shall not be made until at least two days have elapsed.

(b) Each section of the pipe line shall be slowly filled with water and all air shall be expelled from the pipe by tapping at points of highest elevation before the test is made and plugs inserted after the tests have been completed. The specified test pressure based on the elevation of the lowest point of the line or section under test and corrected to the elevation of the test gauge shall be applied by means of a pump connected to the pipe as directed by the Engineer.

(c) The duration of test shall not be less than 5 minutes. The exposed joints hall be carefully examined and all such joints showing visible leaks shall be recaulked until water tight. Any cracked or defective pipes and fittings in consequence of this pressure test shall be removed and replaced by sound material by Contractor at no extra cost to the Engineer and the test shall be repeated to the satisfaction of the Engineer.

(d) After the satisfactory completion of pressure test, the section of pipe line shall be subjected to leakage test. The duration of test shall be 2 hours.

No pipe installation shall be accepted until the leakage is less than the number of cm^3/h as determined by the formula:

$$q_L = \frac{ND\sqrt{P}}{3.3}$$

Where,

q_L = The allowable leakage in cm^3/hr
N = Number of joints in the length of the pipeline
D = Diameter in mm, and
P = The average test pressure during the leakage test in Kg/cm^2

Should any test of pipe laid indicate leakage greater than that specified above, the defective joints shall be repaired by Contractor at no extra cost to the Engineer until the leakage is within the specified allowance.

(e) Necessary equipment and water used for testing shall be arranged by Contractor at his own cost. Damage during testing shall be Contractor's responsibility and shall be rectified by him at no extra cost to the Engineer. Water used for testing shall be removed from the pipe and not released in the excavated trenches.

(f) After the tests mentioned above are completed to the satisfaction of the Engineer, the backfilling of trenches shall be done as per the Employer's Requirements specified elsewhere.

6.16 Manufacturer's Works Acceptance Tests on Electrical Equipment

The following equipment / items shall be subjected to inspection, routine /acceptance tests as per latest edition of relevant Indian / International standards in the presence of Employer/ his Engineer

(a) 415 V metal enclosed switchgears (PCC) /MCC
(b) Variable Frequency Drives
(c) Power & control cables
(d) Cable carrier system
(e) Earthing and lightning protection systems

Copies of test Certificates for the type tests and Special tests not later than 5 years conducted as per relevant Indian / International Standards for all the

equipment /items of above shall be furnished for the perusal of Employer / his Engineer. If type tests and special tests have not been conducted on any of these items, the same shall be carried out in the presence of owner/ Engineer at no extra cost.

6.17 Manufacturer's Works Acceptance Tests on Instrumentation and Associated Equipment

A. Instrumentation:

(a) Inspection, Testing and Setting to Work:

(i) General

Each item of plant shall be subjected to the manufacturer’s own tests which shall be certified.
Each item of plant and its installation shall be subject to inspection and testing at the place of manufacture.
The Contractor shall be responsible for the provision of all necessary test equipment. The Contractor shall demonstrate to the Engineer, the correct operation of any item of plant and the Engineer may witness any test. Tests which, in the opinion of the Engineer, were failed or not performed correctly shall be repeated.

Calibration tests for field instruments and analytical instruments should be conducted on site after installation and the same should be witnessed by the Engineer.

Before any test is made, the Contractor shall submit to the Engineer a full list of test equipment & test procedures (method statements) to be used. Each item of test equipment shall have a standard of accuracy better than that stated by the manufacturer of the item to be tested. The Contractor shall provide evidence of the condition and performance of any item of test equipment, in the form of test certificates issued by an appropriate authority independent of the Contractor and manufacturer, or as otherwise directed by the Engineer. Test equipment shall be checked frequently during the period of the tests.

The Contractor’s staff responsible for supervising and carrying out tests shall be fully conversant with the various items of equipment of other manufacturers and if necessary the Contractor shall arrange for his personnel to attend suitable training courses on his own expense.

Any fault or shortcoming found during any inspection or test shall be rectified to the satisfaction of the Engineer before proceeding with further inspection or testing of that item. Any circuit previously tested, which may have been affected by the rectification work, shall be re-tested.

(b) Preliminary Inspection and Testing at the Place of Manufacture

(i) Field-mounted instruments

After the successful completion of the manufacturer’s own inspection and testing of instruments supplied under the Contract, similar tests shall be carried out in the presence of the Engineer and the Contractor. Such tests shall include a demonstration that an increase or decrease of the measured value at several points over the full range of the instrument produces a corresponding increase or decrease in the instrument output signal. These tests shall include checks on the specified accuracy of the instrument at all points.

(ii) Instrument panels, enclosures and mounting boards

The manufacturer shall not present instrument panels, enclosures and mounting boards (assemblies) for inspection and testing until the manufacturer’s own tests and inspection has been completed. A preliminary inspection and test of these assemblies may then be witnessed by the Engineer. The Contractor shall give not less than 7 days’ notice in writing that he has completed.
His tests and inspection and is ready for the witnessed tests and inspection. Where this notice period is different in the Conditions of Contract this shall take precedent.

The witnessed inspection and testing shall include the following:

a. A visual inspection of the panel assembly to show that the design, construction and finish are satisfactory and in accordance with the Specification;
b. A check that equipment is securely mounted, accessible for removal or calibration without damage to or undue disturbance of other components, wiring or piping;
c. That all engraving and labels are correctly positioned, fixed and designated in accordance with the Specification;
d. Panel power-distribution circuits have the correct breaker/fuse rating coordination and designation;
e. Power-isolation facilities meet the Specification;
f. The main incoming supply voltage, frequency and/or pneumatic supply pressure is within the required limits, these being checked at the beginning and end of the test and the results recorded on test certificates;
g. The output of all power supply units again at the beginning and end of the testing with results being recorded;
h. The power supply voltage or air pressure of all component instruments of the assembly(s), these voltages/pressures being recorded on the test certificate;
i. The insulation resistance of all circuits except sensitive electronic equipment which is liable to damage by application of the test voltage, such circuits being disconnected before making the insulation resistance tests and these tests being carried out in accordance with IEE Wiring Regulations;
j. That the clean earth bar is isolated from main frame of the panel.

Internal lighting and anti-condensation heaters and associated thermostats, isolators, limit switches and wiring shall be checked for compliance with the Specification.

Spare capacity within the panel(s) shall be checked to see that it complies with the Specification. This shall include future equipment space, spare terminals, space in wiring trunkings and provision for additional cable entry.

(c) Functional Testing at the Place of Manufacture

(i) General requirements

Once the preliminary inspection and testing is complete to the satisfaction of the Engineer, functional testing shall commence. The purpose of the functional tests are to demonstrate that instrument panels enclosures and mounting boards (assemblies) conform with requirements of the Specification.

Not less than 30 days before the commencement of functional tests, the Contractor shall submit to the Engineer, for approval, two copies of comprehensive test procedural documents detailing each test to be carried out. The document shall include results forms on which the results of each test will be entered. The forms shall include spaces for numerical values, where necessary, and
witness signatures.

All applicable drawings and data shall be provided at the place of inspection by the Contractor.

The Contractor shall provide all test instruments and equipment necessary to test the assemblies in their entirety.

The following is a typical list of the equipment required:

- Switch boxes;
- Indicator light boxes;
- Analogue signal sources;
- Dummy loads;
- Meters;
- Simulators;
- Programmers for DCS or outstations;
- Insulation test equipment

(i) Factory Acceptance Test (FAT)

The Contractor shall conduct a full programme of tests of the PLC & SCADA system at the Contractor's testing facility in the presence of the Engineer to verify that all features of the system have been provided, are operating correctly and are in full compliance with the Specification. Unless otherwise specified or agreed by the Engineer, the entire PLC & SCADA system shall be assembled and tested together as an integrated system, including all master station equipment, all operators' consoles, all outstations and telemetry equipment all instrumentation panels and uninterruptible power supplies included in this Specification. The scheduled date for the factory acceptance test shall be as agreed by the Contractor and the Engineer at least four weeks before the test.FAT shall be conducted with a hardwired simulation panel connected to the PLC based SCADA system. Contractor shall note the importance of the requirement. No software based simulation testing shall be accepted or allowed.

Not less than one month before the scheduled factory acceptance test, the Contractor shall submit to the Engineer for approval two copies of a comprehensive manual detailing each test to be conducted. The manual shall include a results form on which the results of each test will be entered, including spaces for numerical values where appropriate and witness signatures.
Not less than 7 days before the scheduled factory acceptance test, the Contractor shall give written notification to the Engineer that a complete dry-run of the factory acceptance test has been performed successfully and that, in the opinion of the Contractor, the system exhibits stable operation and is ready for the formal factory acceptance test.

The factory acceptance test will be considered successfully completed only when the system has successfully passed all factory tests. The system shall not be delivered to Site until the successful completion of the factory acceptance test is certified by the Engineer or unless otherwise approved by the Engineer. Delay in the delivery of the system due to failure of the factory acceptance test shall not constitute an unavoidable delay. If the system fails the factory acceptance test, the test shall be extended or rescheduled at the discretion of the Engineer.

All hardware to be used in the testing of the system shall have passed an agreed preliminary hardware performance test to ensure known hardware operability before software testing begins.

After successful completion of the factory acceptance test, no software changes shall be made to the system without written authorisation by the Engineer. Any changes to the system which effect the system software documentation, such as input scale modifications or changes to the control logic, shall be entered into the system documentation before delivery of the system to Site.

(ii) FACTORY ACCEPTANCE TEST PROCEDURES

(a) General

The scope of the tests shall include the proving of every aspect of hardware and software operation and functions as detailed below.

(b) Hardware tests

(a) Verify the correct inventory of hardware including cables and printed circuit boards;
(b) Demonstrate that all spare-memory, disk-capacity and system-expansion requirements have been met;
(c) Demonstrate all hardware and software diagnostics;
(d) Verify all power supply voltages are within tolerance;
(e) Verify proper earth connections and isolation of instrumentation earth for all equipment;
(f) Demonstrate operation of test simulation and indication equipment and its Suitability for adequate functional testing of all system functions.

(c) Software tests

(a) Demonstrate the editing of all system parameters including set-points, timers and the like;

(b) Demonstrate system configuration capabilities including the addition and deletion of input and output points, outstations, and all data base parameters;
(c) Demonstrate the addition, deletion and modification of mimic displays and report formats;

(d) Functional tests

The functional tests shall verify proper operation of every specified system function as an integrated system. These tests shall be conducted in conjunction with functional tests of instrumentation and control panels as specified elsewhere. All failures or discrepancies found shall be documented in the test manual.
Following a failure of any functional test, should software or hardware modifications be required it shall be the decision of the Engineer whether the factory acceptance test is to continue, re-start or be aborted. If testing is allowed to continue, any changes which are required shall be described in a system modification document, signed by both Contractor and Engineer and be incorporated into the final factory acceptance test documentation. The failed test shall be re-conducted and the Engineer may require the retest of functions which may be affected by the modification.
The functional tests shall include, as a minimum, the following:
(a) Demonstration that the system meets the requirements of the Specification for response time and speed of screen update
(b) Verification of the accuracy of all analogue input points in the system. The procedure shall include applying the appropriate signal to each analogue input at a minimum of three points within the range of the input, checking for expected numerical results, and verifying appropriate update of related mimic displays. Proper sensing and action by the system to high and low out-of-range inputs shall also be verified
(c) Verification of the proper logic sense, pulse accumulation and rate computation where appropriate, of all digital inputs and verifying appropriate update of related mimic displays;
(e) Verification of all control and sequencing operations and proper operation of all digital and analogue outputs. The procedure shall include simulation of all related process variables for both normal and abnormal conditions, including

instrument and component failure, and demonstration of fail-safe response of the system. System outputs shall be indicated with appropriate lamps and indicators;

(f) Simulation of outstation communications errors and failures and demonstration of error detection and handling, failure detection and handling, and appropriate changes to control actions as designed and specified;

(g) Verification of fault detection and diagnostics by inducing a sufficient variety of fault conditions in the system to ensure that detection processes and fail-safe operation are adequately tested;

(h) Demonstration of proper operation of all mimic displays, help pages, reports, operator procedures and historical data accumulation;

(j) Demonstration of proper operation of all outstations following a simulated master station central processor failure;

(k) Demonstration of proper operation of all equipment during both a system wide or isolated power failure, and following power restoration. The procedure shall include the demonstration of battery backup of both master station and outstation for the full length of time specified, and proper operation of power fail, low voltage warning and all associated alarms.

(e) Reliability test

After successful completion of the functional tests a 48-hour continuous run of the system shall be performed. The test shall be passed if no system function is lost or no hardware or software failure occurs. Hardware failure is defined for this test as the loss of a major component such as the computer, an outstation, a VDU or a peripheral device. Non-repetitive mechanical failures of loggers, push-buttons and the like are excluded.

During this test, the system shall be exercised with simulated inputs and conditions in a manner which approximates the on-site operational environment. Unstructured testing by the Engineer shall be included during this test. Upon any system failure during this period, it shall be the decision of the Engineer whether the reliability test is to continue or be aborted. If testing is allowed to continue any changes to the system which are required shall be described in a system-modification document, signed by both Contractor and

Engineer and the document shall be incorporated into the final factory acceptance test documentation.

(f) Factory acceptance test documentation

As a minimum, the following information shall be included in the factory Acceptance test manual for each test:

- Test identification number;
- Test name and description;
- List of all equipment to be tested including any special test equipment required;
- Description of the test procedure broken down into logical steps;
- Description of the expected system response verifying the completion of each logical step;
- Space for recording the results of the test and the time and date of the test;
- Space for signatures of the Contractor and the Engineer.

In addition, the Contractor shall provide a method for recording and tracing all problems, discrepancies, queries and suggestions regarding the system and software, and for formalised control of any modifications to the system.

(i) Pre-commissioning tests

The Contractor shall perform pre-commissioning, or preliminary, testing of the SCADA system in accordance with that specified for instrumentation. The purpose of pre-commissioning tests is to confirm readiness of the system for commissioning.

The scope of pre-commissioning tests shall be generally as specified for factory acceptance tests but real field inputs and final control elements shall be used wherever practical to provide inputs to the system and to confirm proper outputs.

Where this is impractical, simulation signals shall be injected as near as possible to their ultimate sources so as to include in the tests as much of the cabling system as possible.

Each process system shall be set to work under manual control and the system tested to confirm proper operation. After proper operation of manual control mode has be verified, tests of automatic controls of each process system shall be conducted wherever practical.

(ii) Commissioning

All the equipments shall be commissioned as per the manufacturer's recommendations and in presence of the manufacurer's representative.

(a) Site Acceptance Tests (SAT)

The Contractor shall submit all relevant draft operating manuals for the PLC & SCADA System to the Engineer for approval prior to commissioning tests.

Any faults or failures of the system detected during the previous tests shall be noted and corrected to the satisfaction of the Engineer before commissioning is allowed to commence.

As part of commissioning, the PLC & SCADA system shall be tested for availability for a continuous period of 30 days. During this period, the system will perform the normal functions according to the procedures described in the SAT documentation approved by the Engineer.

The system shall have passed the SAT if all major components have been free from fault or failure and exhibit full error-free functionality for 100 % of the total duration of the test, unless otherwise agreed by the Engineer. Major components include all master station equipment, outstations, communications facilities and instrument panel components, excluding push-buttons, switches and lamps and any equipment not supplied by the Contractor.

During SAT, no modifications to the system shall be made by the Contractor without the written approval of the Engineer. Erroneous functioning which requires software modifications or re-configuration to correct, other than set-

point or parameter changes, shall constitute a failure of the availability test. Any changes to the system which are required and approved shall be described in a system-modification document, signed by both Contractor and Engineer and the document shall be incorporated into the final test documentation. The test shall be restarted after corrections have been made.

6.18 Inspection at Site

During erection of the Plant the Engineer will inspect the installation from time to time in the presence of the Contractor's Supervisor to establish conformity with the requirements of the Specification. Any deviations found shall be corrected as instructed by the Engineer.

6.19 Plant protection on Site

Factory finished plant shall be adequately protected both before and during installation against damage to finished surfaces, fitted components, and the ingress of dust. It may be necessary for structural finishing operations to be carried out in the vicinity of installed plant before it is taken over and the Contractor shall take this into consideration in complying with the requirement of this clause.

6.20 Erection staff

The Contractor shall provide at least two approved senior English speaking working erectors to supervise the erection of all Plant in the Contract and in each case to act as the Contractor's Representative as set out in Clause 13 of the general conditions of contract.

In the case of a foreign firm based overseas the Contractor's Representative shall be thoroughly conversant with the manufacturer's Plant and equipment, and its erection and shall be an expatriate.

The Contractor shall also provide sufficient erectors skilled in electrical, mechanical and instrument engineering, with such skilled, semi-skilled and unskilled labor as are necessary to ensure completion of the various sections of the Contract in the time required. The Contractor shall not remove any supervisory staff or labor from the site without the prior approval of the Engineer.

The Engineer will give the Contractor at least one month's notice in writing of the date on which the erection staff will be required on site, and he Contractor shall confirm the date of arrival in writing to the Engineer. The Contractor shall make all the necessary arrangements to ensure that sufficient plant has been or is about to be delivered to site, so that there shall be no delay to the start of erection.

It shall be the responsibility of the contractor to obtain necessary License / Authorization n/Permit for work from the Licensing Boards of the Locality/State where the work is to be carried out. The persons deputed by the Contractor's firm should also hold valid permits issued or recognized by the Licensing Board of the Locality/State where the work is to be carried out.

6.21 Erection and Building-in

The installation work shall comply with the latest applicable Standards, Regulations, Electricity Rules and Safety Codes of the locality where the installation is to be carried out. Nothing in this specification shall be construed to relieve the Contractor of this responsibility.

It will be the Contractor's responsibility to obtain approval/clearance from local statutory authorities including Electrical Inspector, wherever applicable for conducting of any work or for installation carried out which comes under the purview of such authorities.

The Contractor shall carry out the complete erection of all plant, including the provision of all necessary skilled and unskilled labor, material, transportation, supplies, power and fuel, Contractor's Equipment and appurtenances necessary, for the complete and satisfactory erection of the Plant.

The Contractor shall have a separate cleaning gang to clean all equipment under erection and as well as the work area and the project site at regular intervals to the satisfaction of the employer. In case the cleaning is not up to the employer's satisfaction, he will have the right to carry out the cleaning operations and any expenditure incurred by the employer in this regard will be to the Contractor's account.

(b) Erectors

The Contractor's employees shall include skilled erection staff in sufficient number, who shall arrive on the site on or before the respective dates set out in the approved work programmed and prior to delivery of any item of Plant to the Site. The Engineer will not entertain any claim by the Contractor in respect of delayed erection due to a delay in the delivery of any items of Plant to the site.

(c) Contractor's Equipment, materials and appurtenances

The Contractor shall have available on the Site sufficient suitable equipment and machinery, as well as all other materials and appurtenances required by him, of ample capacity to ensure the proper erection of Plant and to handle any emergencies such as may normally be expected in work of this character.

The Contractor shall be responsible if any installation materials are lost or damaged during installation. All damages and thefts of equipment/component parts, after takeover by the Contractor, till the installation is taken over by Employer shall be made good by the Contractor to the satisfaction of Engineer.

(d) Workmanship

Plant shall be erected in a neat and workmanlike manner on the foundation and at the locations and elevations shown on the approved drawings and other Engineering documents. Unless otherwise directed by the Engineer the Contractor shall adhere strictly to the aforesaid drawings and no departures there from will be permitted.

All plant shall be correctly aligned, leveled and adjusted for satisfactory operation and shall be installed so that the proper and satisfactory connection can be made readily between the various units and pipe work and equipment installed under the Contract. The mounting arrangements for pumpsets and blowers shall be such that the alignment offset between motors and the driven equipment shall be well within 0.1 mm.

(e) Building-in

Erection of Plant shall be phased in such a manner so as not to obstruct the work being done by other contractors. Before commencing any erection work, the Contractor shall check the dimensions of structures where the various items of plant are to be installed, and shall bring any deviations from the required positions, lined or dimensions to the notice of the Engineer and shall take such measures as are necessary for their correction.

The Contractor shall take particular care for the correct positioning and alignment of all puddle pipes which are required through concrete structures prior to, and during the pouring of concrete.

The Contractor shall pin and plug in the holes prepared, all small clips, plugs, screws, nails, sleeves, inserts, etc., required for fixing electric wires and conduits, small pipe work and all other apparatus.

The Contractor shall align all equipment and holding down bolts and shall inform the Engineer before proceeding with grouting-in the item or item concerned. The Contractor shall ensure that all equipment is securely held and remain in correct alignment before, during and after grouting-in.

The Contractor shall properly bed in cement grout each item of plant or its supporting base resting on foundations, and shall grout-in where required holding down bolts placed in the holes prepared in the foundations. The materials and workmanship used in grouting shall be such as will result in a solid anchoring of foundation bolts and complete filling of the gaps between the Plant or its base and the foundations, without shrinkage or cracking.

During erection of the Plant the Employer will inspect the installation from time to time in the presence of the Contractor’s Site representative to establish conformity with the requirements of the Specification. Any deviations and deficiencies found or evidence of unsatisfactory workmanship shall be corrected as instructed by the Employer.

All plant shall be installed in accordance with the recommendations or instructions of the manufacturer, for the particular application. Each mounting position shall be chosen to give correct operation of the equipment, ease of operation, access for maintenance and servicing and freedom from any condition which could have adverse affects.

(f) Precautions

The approval by the Engineer of the Contractor's proposals for rigging and hoisting of any item of plant into its final position shall not relieve the Contractor from his responsibility for avoiding damage to completed structures, parts or members thereof or other installed equipment. He shall at his own cost make good, repair or replace any damaged or injured items whether structural, mechanical, electrical, architectural, or of any other description, promptly and effectively to the satisfaction of the Engineer.

No plant or other loads shall be moved across the floors of structures without first covering the floors with timber of sufficient size so that applied loads will be transferred to floor beams and girders of steel or concrete. If it is required to reduce bending stresses or deflection, the beam and girders shall be provided with temporary supports. Any movement of Plant and other loads over the floor structures shall be subject to the prior approval of the Engineer.

Inspection after Erection

After the erection of any item of Plant and its associated equipment has been completed, it shall be offered to the Engineer for inspection in its static state prior to commissioning the item.

Completion of erection and procedure prior to setting to work.

The mechanical completion of plant under erection shall be deemed to occur if all the units/systems of the Works are structurally and mechanically complete as noted below:

All rotary, static, structural equipment, piping, electrical/instrumentation and other equipment under the scope of the Contract have been erected, installed and grouted and are as per the specifications.

All systems have been washed/flushed/drained/boxed up where necessary.

All system testing including pressure, vacuum and nondestructive tests, no load tests and such other tests are completed with safety valves/relief valves set to operating conditions installed in position.

All panels, local control desks erected with power/control cable terminations with all continuity checks, insulation checks and other installation checks are carried out.

Prior to pre-commissioning checks, the Contractor shall erect the entire Plant and ensure readiness of civil works to the satisfaction of Employer, so that the Works are physically ready to undergo pre-commissioning checks. Pre-commissioning checks will include checks like no-load running of machinery, checks on instruments and electrical including calibration and loop checks, functional checks, inter-lock checks etc.

At the stage of mechanical completion of erection, the Contractor shall ensure that all the physical, aesthetic and workmanship aspects are totally complete and the Plant is fit and sound to undergo pre-commissioning checks.

The following documentation shall be completed before the Contractor notifies Mechanical Completion of Erection to the Employer

26 All shop inspection records compiled and bound in 4 (four) copies.
27 All erection and commissioning procedures duly approved.
28 All instruction manuals in draft form - with each sheet bearing a stamp to indicate "DRAFT FOR REVIEW ONLY" submitted in 4 (four) copies.

Upon achieving mechanical completion, the Contractor shall notify the Employer of such completion of section/units/systems and readiness for inspection for acceptance of mechanical completion of erection. The Employer/ Engineer shall proceed with inspection of such sections/units/systems within 10 days of such notice.

Consequent to inspection, the Employer will inform the Contractor a list of deficiencies for rectification and the Contractor shall complete the rectification work within a jointly agreed period prior to start of pre-commissioning tests. The erection period allowed by the Contractor shall include all activities of mechanical completion as noted above.

6.22 Site Acceptance Test Document

Fifty six (56) days prior to commencement of Tests on Completion the Contractor shall supply a Site Acceptance Test (SAT) Document for approval. This shall comprise four copies of the details of the inspection and test procedures to be carried out in testing the Works.

The SAT Plan shall provide comprehensive details of the tests to be carried out, the purpose of each test, the equipment to be used in carrying out the test and the methods to be adopted in carrying out the tests. The SAT shall provide space within the documentation for results of the tests to be added and for each test and for the SAT as a whole to be signed off by the Contractor and the Engineer.

The SAT shall categorise tests as follows:

a) Dry tests

Dry tests are those tests carried out without process fluid being present.

b) Wet tests which can be further sub-divided into

(1) Hydraulic tests

Hydraulic wet tests are those tests carried out with potable water in order to prove the hydraulic capability of the Works.

(2) Process tests /System tests

Process wet tests are those tests carried out with raw Sewage as the feed stock to prove the process capability of the Works.

The Contractor shall make his own arrangements for water supply, chemical, electric power, fuel, instrument and labour during hydraulic wet tests.

It shall be assumed that the co-operation of other contractors in the carrying out of Tests on Completion will not be unreasonably withheld.

6.23 Tests on Completion

General

Prior to the commencement of Tests On Completion the Contractor shall submit for approval the following:

(1) Site Acceptance Test Documents

(2) As-Built Drawings
(3) Operation and Maintenance Manuals
(4) Site test results / data sheet and photo

Tests on Completion shall not be commenced until the aforementioned documents are approved.

The initial charges of oil, grease, electrolyte, generator fuel / oil, chemical, disposal of cake, etc. necessary for Tests on Completion shall be provided by the Contractor. Raw Sewage and electricity required for Tests on Completion will be provided by the Employer free of charge. If necessary, Contractor shall create design loading conditions for testing purposes by testing fewer than the total number of installed units of process tanks or equipment at a time. In such cases, multiple tests shall be conducted to ensure that all installed units are tested. In the event that raw sewage/influent wastewater is not available at the plant, the Contractor shall defer testing until such time as sewage becomes available for treatment as described elsewhere in these Bid Documents. The Contractor shall provide adequate notice (this notice period shall be determined by the normal lead time for locally purchased chemicals plus at least 28 days) of his chemical requirements prior to commencement of the Tests on Completion involving their use.

The cost of chemicals used for the Tests on Completion shall be met by the Contractor.

The inspection and tests procedure which will be carried out are provided under the general conditions of contract- Clause -- and shall also consist of the following:

a) Manual Commissioning Tests (Clause i)

Manual Commissioning Tests shall be such preliminary trials, tests and retests on individual items of Plant or complete systems as are required by the Engineer in order to demonstrate that the Plant as a whole is ready to undergo the Manual Operation Tests (Clause 3.11) and that these will take place with a minimum of interruption.

The Manual Commissioning Tests shall demonstrate not only the items of Plant under normal operation, but also their response to abnormal and emergency conditions.
The Engineer will notify to the Contractor which items of Plant will be tested and the extent to which they will be tested in order to fulfill the requirements of the Specification.

Leakage tests at 1.5 maximum working pressure shall be carried out on all erected pipe work prior to the Manual Commissioning Tests.

Pump curves shall be available for the Manual Commissioning Tests and all instruments essential for the tests shall have been calibrated.

b) Manual Operation Tests (Clause ii)

When the Manual Commissioning Tests have been completed so that the items of Plant have been demonstrated to the satisfaction of the Employer Representative, the Contractor shall commence the Manual Operation Tests.

These tests shall demonstrate the correct operation of the whole Plant whilst using the minimum quantity of automatic control and monitoring equipment. Such equipment shall be at least that required both for the maintenance of safety and for the normal mode of operation of the Plant.

The Plant will be required to demonstrate satisfactory operation at all design flow rates.

The tests shall be of seven consecutive days' duration; if the supply of water should fail or other matters interfere outside the Contractor's control, the tests may be of such number of broken days as the Engineer considers is the equivalent.

The exact date of commencement shall be subject to the approval of the Engineer and shall be dependent on the following conditions having been met

(1) All relevant items of Plant in approved working order
(2) All items of Plant correctly identified with labels

c) Automatic Commissioning Tests (Clause iii)

The Automatic Commissioning Tests shall be such preliminary trials, tests and retests on individual items of Plant or complete system as are required by the Engineer in order to demonstrate that the Plant as a whole is ready to undergo the Tests of Completion (Clause 3.13) and that these will take place with a minimum of interruption.

At least one week before the commencement of these tests, the Engineer will notify the Contractor which items of Plant will be tested and the extent to which they will be tested in order to fulfill the requirements of the specification.

The Tests on Completion (Clause 3.13) as provided under the general conditions of contract-clause 37 shall not be carried out until the completion of the above tests.

(1) All pipe work shall be hydrostatically tested at site to a pressure equal to 1.5 times the maximum working pressure likely to be encountered in the system.

(2) The Contractor shall carry out all tests on the Plant and shall supply four copies of all test results to the Engineer.

(3) All tests shall be to the approval of the Engineer who may require them to be repeated, prolonged or modified as may be necessary to ensure that any or all items of Plant conform to the Contract.

(4) The Engineer shall be permitted to inspect all Plant which is undergoing tests and may himself conduct tests.

Where it is necessary for the Engineer to make arrangements for the supply of water, chemicals, power, etc., for any testing, the Contractor shall not commence the tests until after these arrangements have been made on or after a date agreed by the Engineer and the Contractor shall make no claim for delay to such testing on this account except as provided for under Clauses 44 of the General Conditions of contract.

If any item of plant fails during or after testing to achieve its intended duty or otherwise proves defective, it shall be modified or altered as necessary and re-tested and re-inspected as required by the Engineer.

Vibration/noise level tests shall be carried out at site which will form basis for acceptance of the equipment. If the Contractor is not in a position to meet the requirements given below as per ISO 10816 – 1995, the equipment may either be rejected or the Contractor shall carry out all necessary modifications to keep vibrations within the acceptable limits specified.

Equipment	Noise Level (dBA at 1.86 m from equipment)	Velocity of vibration (mm/sec)
All rotating equipment not having reciprocating parts with motor kW less than or equal to 15 kW	85	1.12
All rotating equipment not having reciprocating parts with motor kW more than 15 kW and less than or equal to 75 kW	85	1.8
All rotating equipment not having reciprocating parts with motor kW greater than 75 kW	85	2.8
All equipment having reciprocating parts viz. compressors, dosing pumps sampling pumps	85	-

The Contractor shall have a minimum of two commissioning engineers, one for process and plant and the other for electrical/instrumentation works on site during all tests in order to both demonstrate the Plant and to correct any faults which may occur.

6.24 Dry Test Requirements

As a minimum requirement the following dry tests shall be carried out as a general requirement:

(1) A general inspection to check for correct assembly and quality of workmanship

(2) A check on the presence of lubricant, cooling medium, electrolyte, etc.

(3) A check on adequacy and security of Plant fixing arrangements.

(4) A general check to ensure that all covers, access ladders, water proofing, guard railings etc are in place.

(5) A check on damp-proofing, rust-proofing and vermin-proofing and particularly the sealing of apertures between building structures, chambers etc and the outside.

a) Civil and Building Works

As a minimum requirement the following dry tests shall be carried out on the civil engineering and building works:

- Check for the presence of foreign bodies in pipe work and structures.

b) Mechanical Works

As a minimum requirement the following dry tests shall be carried out on the mechanical systems:

- Carry out preliminary running checks as far is permitted by circumstances in order to ensure smooth operation of Plant.

c) Electrical Works

As a minimum requirement the following dry tests shall be carried out on the electrical systems:

(1) Check phasing and polarity.

(2) Carry out point to point check on all cables.

(3) Check on security of cable terminations.

(4) Check on completeness and adequacy of earthing systems.

(5) Check setting on protection relays, sizes of fuses and motor overload settings.

(6) Carry out checks on cabling systems in accordance with the requirements of the relevant standards.

(7) Check operation of main circuit breakers by secondary injection methods.

(8) Check rotational direction of Plant.

(9) Check instrument loop integrity, functionality and calibration.

(10) Check operation of standby generator installation and mains / generator changeover procedures; a 4 hour load test (using the normal load of the Works) shall be carried out on the generator when the load is available.

(11) Check plant functionality.

(12) Check functionality of the central MMI and its power supply.

6.25 Process Plant Item / Equipment

All process plant items / equipment shall be tested to ensure they meet the Employer's Requirements for quality of workmanship, construction and performance.

6.26 Hydraulic Wet Test Requirements

Hydraulic wet tests shall be carried out on completion of dry tests.

Clear Water shall be used for hydraulic wet tests. The purpose of the tests is to prove the hydraulic performance of the Works. In order to demonstrate this, the Contractor shall ensure that each part of the Works is hydraulically loaded to its rated throughput for a period of at least four hours.

In order to ensure a sufficient supply of water to carry out these tests the Contractor shall provide all required facilities, including but not limited to any temporary facilities that may be required for storage and recycle of Clear Water or facilities for the disposal of the water off Site in an approved manner.

The following tests inter alia shall be carried out:

(1) Pressure testing of all piped systems laid direct in ground in accordance with the relevant standards.
(2) Fill all structures and check for leaks.
(3) Filling of all storage vessels to check for leaks and distortion.
(4) Running of all pumped systems in order to check for.
i) Correct functionality.
ii) Absence of leaks.
iii) Correct running temperatures.
iv) Smoothness of running and the absence of undue vibration or stress.
v) Check drive running currents.
(5) Carry out calibration of instruments where appropriate.
(6) Carry out valve operation, diversions etc. to fully hydraulically load each process element (or where there is a requirement to withstand an over load), overload each process element.
(7) Demonstrate correct functionality of electrical, control and instrumentation systems.

The Contractor shall simulate the conditions that will prevail when operating as a process in order to demonstrate the correct functionality of process control loops etc.

During these tests a check on the performance of Plant shall be made to compare its site performance with the factory test data and to identify any constraints on performance due to site conditions.

6.27 Safety Audit

After satisfactory completion of hydraulic wet tests and prior to introduction of process fluid to the plant a safety audit shall be carried out to ensure compliance with the necessary requirement for safety and for operation of Plant. The safety audit shall be documented. The safety audit document shall be approved by the Engineer prior to commencement of Plant commissioning.

6.28 Process Wet Tests (with Raw Sewage)

On approval by the Engineer the Contractor shall carry out process wet tests.

Raw Sewage shall be used as the primary feed stock for process wet tests. These tests shall be carried out to demonstrate the process performance of the Works. In order to demonstrate this, the Contractor shall ensure that each part of the Works is loaded to its rated throughput (including a period of overload if required in order to demonstrate compliance with the Employer's Requirements) for a continuous stable operating period of not less than 48 hours. If necessary, Contractor shall create design loading conditions for testing purposes by testing fewer than the total number of installed units of process tanks or equipment at a time. In such cases, multiple tests shall be conducted to ensure that all installed units are tested. In the event that raw sewage/influent wastewater is not available at the plant, the Contractor shall defer testing until such time as sewage becomes available for treatment as described elsewhere in these Bid Documents.

The Contractor shall provide all required facilities for the disposal off Site in an approved manner.

The following tests inter alia shall be carried out:

(1) Check for leaks on vessels, structures, pumps and pipe work.
(2) Running of all pumped systems in order to check for.
    - ✓ Correct functionality.
    - ✓ Absence of leaks.
    - ✓ Correct running temperatures.
    - ✓ Smoothness of running and the absence of undue vibration or stress.
    - ✓ Check drive running currents where the solution pumped is different from that pumped during hydraulic wet tests.
(3) Carry out calibration of instruments.
(4) Carry out valve operation, diversions etc. to fully hydraulically load each process element (or where there is a requirement to withstand an over load), overload each process element.
(5) Demonstrate correct functionality of electrical, control and instrumentation systems not checked during dry or hydraulic wet tests or which may have changed as a result of the different operating conditions now prevailing.

On completion of the tests on the various parts of the works the Contractor shall run the plant as a whole in order to demonstrate the full functionality and performance of the Works at various throughput rates for a continuous period of not less than 15 days.

During the various process tests the Contractor shall take samples and carry out Sewage quality analysis at not greater than one-hour intervals in order to demonstrate to the Engineer that the Works is functioning in accordance with the Employer's Requirements. Each sample shall comprise two 1 litre (minimum) quantities and shall be labelled to identify the contents, where taken and time and date. The flow recorded at the time of sampling shall also be indicated in the log book or record. One sample shall be used by the Contractor for his analysis; the other shall be handed over to the Engineer.

The Engineer reserves the right to take additional samples and to carry out his own tests or to check the samples taken by the Contractor.

The Engineer shall be given reasonable access to the premises where analysis is taking place in order to check on working practices and the procedures being adopted.

6.29 Co-operation with other Contractors in the Execution of their Tests

The O&M Contractor shall, where required, assist other contractor in carrying out their tests on completion and or tests after completion.

6.30 Operation Test (Tests After Completion)

(a) General

On successful completion of "Test on Completion" the Contractor shall carry out all the equipments before Taking over.

All defects identified prior to Taking Over and defects identified during the six months operation of the Works have been rectified.

All Tests "After Completion" have been completed to the satisfaction of the Engineer.

End of Part 6